

Work Order ID 53019



Page 1

October 22, 2009 9:44:11 AM

Item ID: D2656-37

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 21/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *RF*Date: *09/10-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2656	Rev D								

100



FLOW WATER JET

Waterjet

Memo

0.00

FB 9-11-3

FLOW CNC Waterjet

1-Cut as per Dwg D2656 Dwg Rev: *D* Prog Rev: *D* 2-
Deburr if necessary*(B)*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

FB 9-11-3

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

*→S 02/10/09**(A/3)*

QC

Memo

0.00

Quality Control

Work Order ID 53019

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Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run
					Start
	QC:	Date:	SPC (Y/N):	Date:	Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

0.00

N/A

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

140



NC BRAKE

0.00

13

-0

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. 2-
Identify as D2656-37

85 09/10/17

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=> 809/10/17

(X13)

f

Work Order ID 53019

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Start Date: 21/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Grey Sandtex(Ref:4.3.5.6) per QSI005.4.3

0.00

M1128588
=7/11/09/00/19

(X13) - Ø

Powdercoat

Powder Coating

Memo

0.00

START TIME: 9:00AM OVEN TEMPERATURE:
FINISH TIME: 5:30PM

170



QC3- Inspect Part Finish

0.00
BL 09-11-19
0.00

(13) _____

QC

Quality Control

Memo

180



Identify as per dwg & Stock Location: FP.20

0.00

0.00
M 08/11/19

(X13) 0 _____

Packaging

Packaging

Memo

Work Order ID 53019

Page 4

October 22, 2009 9:44:11 AM

Item ID: D2656-37

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 21/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19

PL 09-11-19
(13)

Picklist Print

Page 1

October 22, 2009 9:44:19 AM

Work Order ID: 53019



Parent Item: D2656-37RevD



Parent Item Name: Wearshoe

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S20GA		Purchased		No		100	sf	158.5000	6.7971	7.3635		

1010/1025 SHEET



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT	Loc Qty	Loc Code
102684	1	
103258	1.5	
103788	2	
103840	2	
104184	1.54	
104921	8.5	
106069	2	
106478	4	
106671	1.46	
107906	2	
108275	3	
109289	1.5	
111410	128	111410

(13)

DART AEROSPACE LTD	Work Order:	53019
Description: Wearshoe	Part Number:	D2656-37
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>RS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	9-15-03	Date:	09/16/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	
B	08.11.27	Dimensions updated per Dwg Rev. D	KJ/EC	

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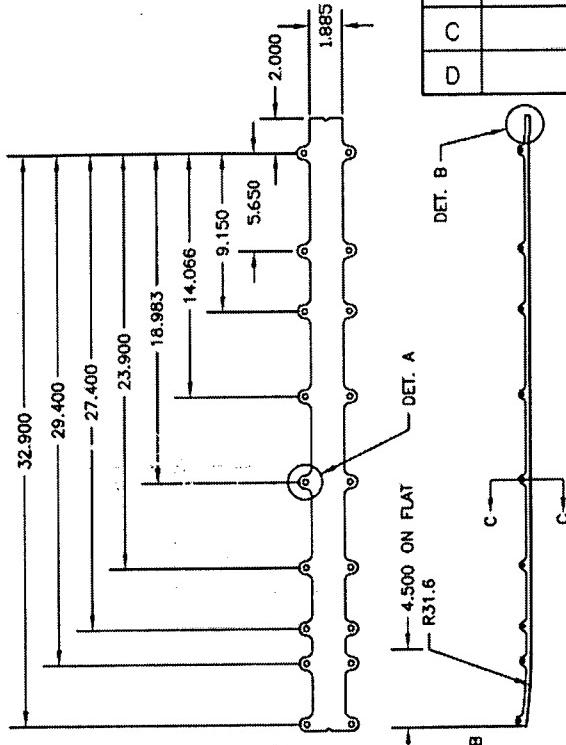
WORK ORDER

NO. 53019 By 09-10-22

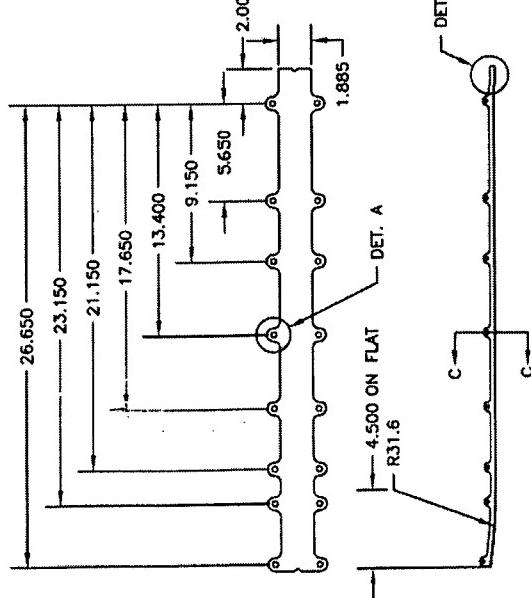


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DS	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2656
		REV. D
		SHEET 1 OF 4
DATE	TITLE	SCALE
05.08.17	WEARSHOE	1:10
A	97:03:25	NEW ISSUE
B	97:06:02	CHANGED TABS
C	97:06:26	R31.6 WAS R19.5
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT

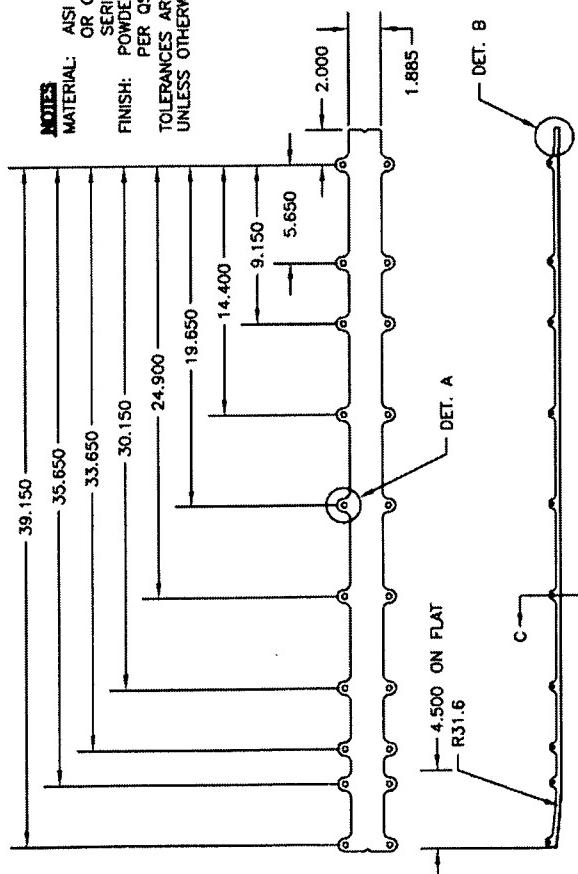
D2656-13



D2656-11



D2656-15

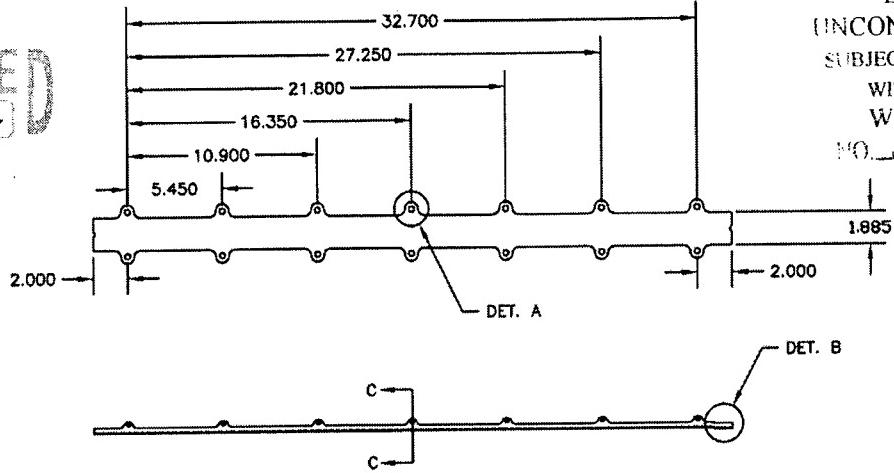


NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

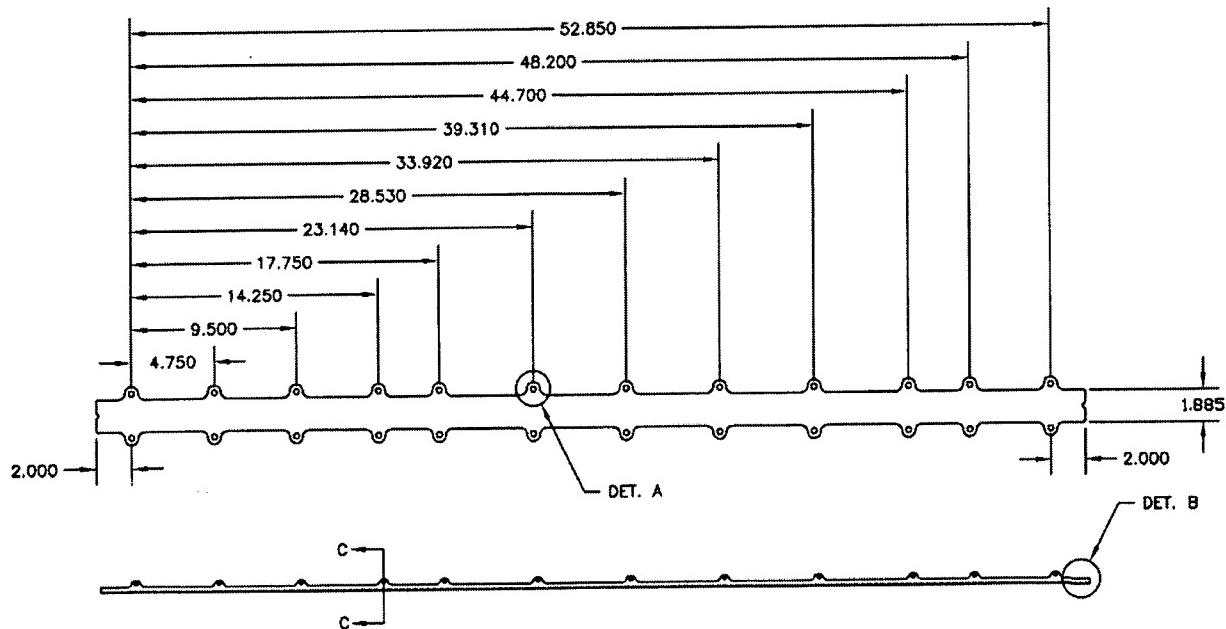
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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05.09.06 *A*

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D2656-23**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

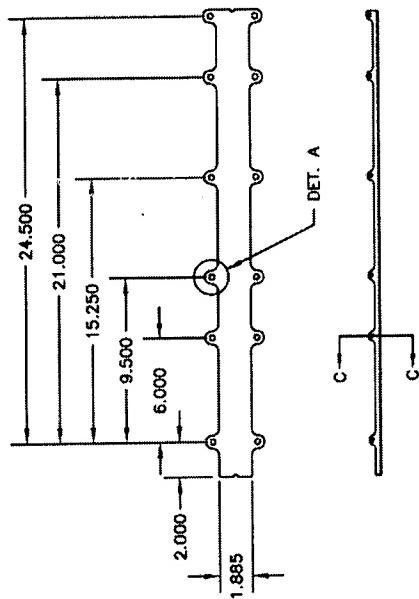
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UNLESS OTHERWISE NOTED

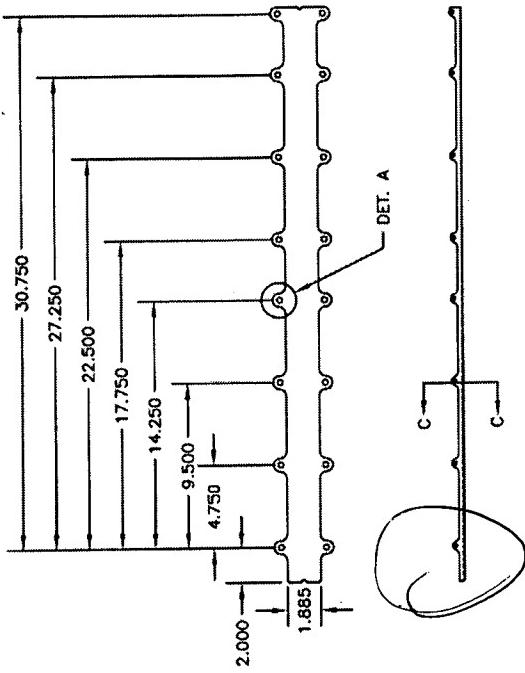


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DATE				TITLE	SCALE
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D2656-31



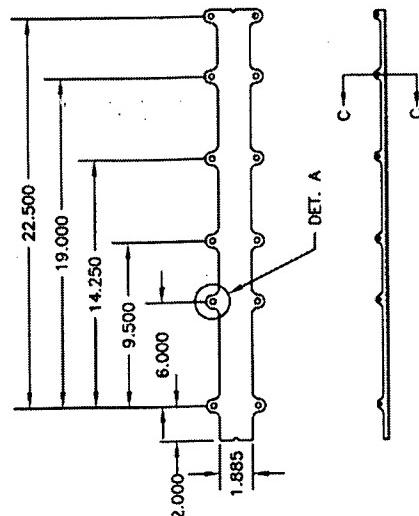
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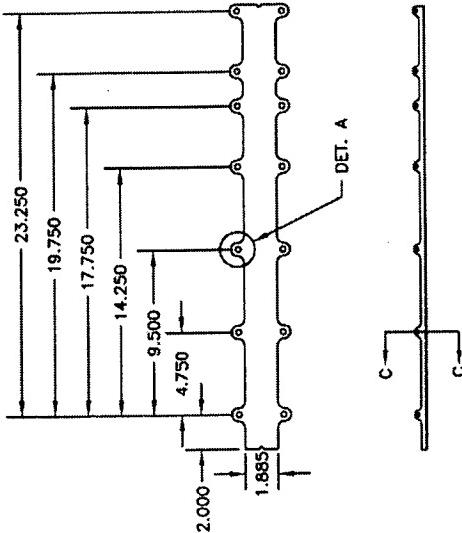
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D2656-35



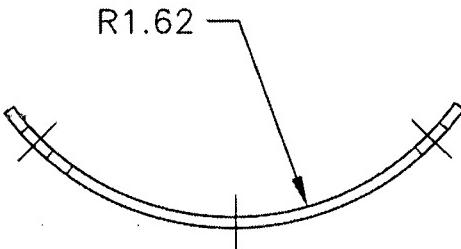
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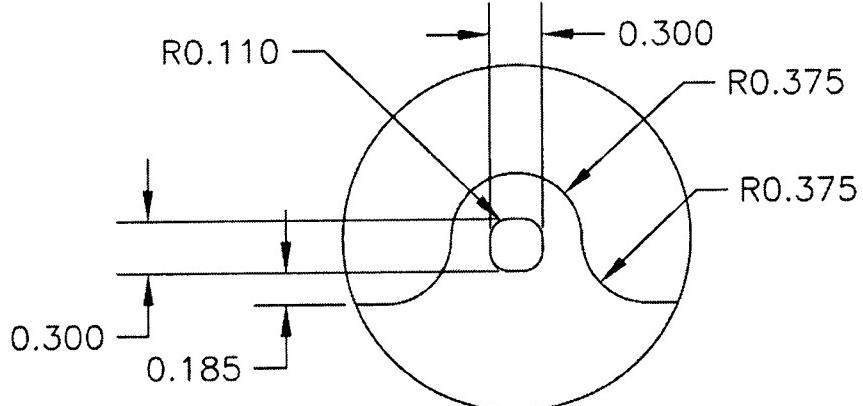
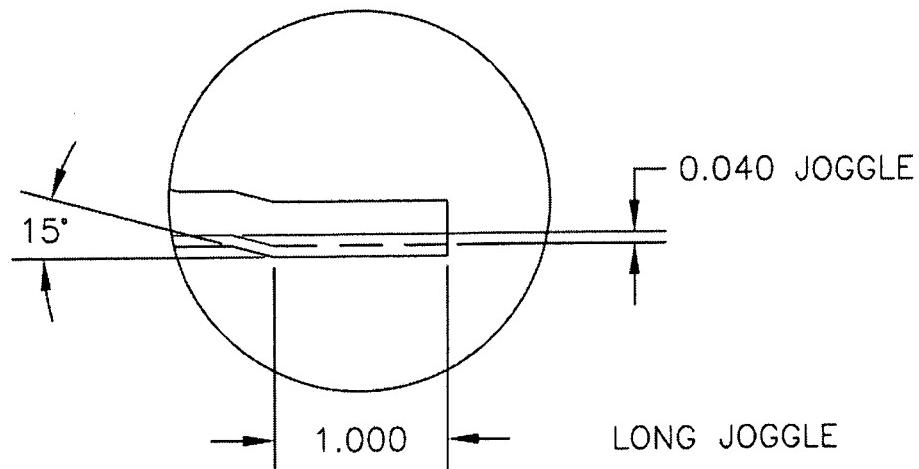
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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